

S261728



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

POSITIVE RECALL

EFFECTIVE 20/03/09 AUTH. S.H.

DAS

RELEASED 55 - DATE MAR 10 2020

9-89

D5787-3

Job Sheet 207471



Part No: D5787-3

Job Qty: 12 pcs

Part Name: Placard



Part Weight: 0 lbs

Job Created: 2/26/20

Due Date: 3/27/20

Type: Stock

Status: New

Job Tracking No:

Created By: Jennifer Renwick

Description:

Priority: Medium

Note: URF 2020-525 DWG 5787 REV.A IPP REV:A NEW ISSUE 20.31.01 JV VERF:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Waterjet - Flow - 1	12 pcs	3/27/20	3/27/20	0.17	1.50	Waterjet - Flow		
100	NV5000 - 1 - B4B	12 pcs	3/27/20	3/27/20	1.00	1.00	NV5000 - 1 - B4B		20/03/09
							NV5000 - 2 - B4B		ALA 20/03/10
110	QC 2	12 pcs	3/27/20	3/27/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

Plex 3/3/20 8:18 AM Dart.Renwick.Jennifer



120 QC 8 12 pcs 3/27/20 0.00 0.00

See Pat Duval or Nazim
Acceptable to
stock, but not ship
NO 20.05.10

DAS
55
9-89

MAR 10 2020

QC 2 - 64

QC 2 - 65

QC 2 - 5

QC 2 - 71

QC 2 - 73

QC 2 - 69

QC 2 - 76

QC 8 - 12

QC 8 - 14

QC 8 - 17

QC 8 - 20

QC 8 - 25

QC 8 - 3

QC 8 - 32

QC 8 - 33

QC 8 - 35

QC 8 - 39

QC 8 - 4

QC 8 - 44

QC 8 - 45

QC 8 - 49

QC 8 - 58

QC 8 - 8

QC 8 - 9

QC 8 - 68

QC 8 - 67

QC 8 - 1 (A)

QC 8 - 47

QC 8 - 40

QC 8 - 52

QC 8 - 23

QC 8 - 57

QC 8 - 76

QC 8 - 61

20/03/10

130 Packaging 3-1 - Stock - B4B 12 pcs 3/27/20 0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

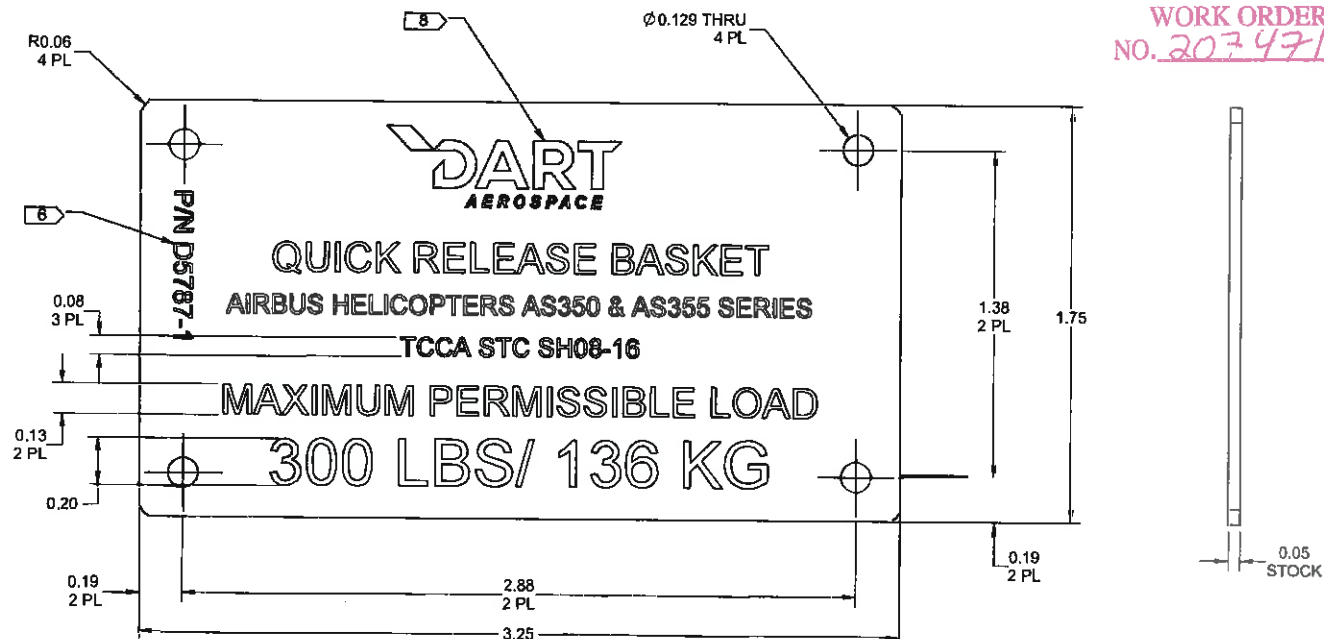
DAS
28
9-89

				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	12 pcs	3/27/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 90 - ****ONE BLANK MAKES 3 PARTS**** 1-Cut blank 2-Debur if necessary Descriptions: 100 - 1-Machine as per folio FD167 FOLIO REV: <u>AA</u> DWG REV: <u>A</u> 2- REMOVE TAB 3-Debur 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - Identify as per dwg & Stock Location: 140 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6S.050	6061-T6 .050 Sheet	.4968 sf (.0414 ea)	90-Waterjet - Flow - 1	5048658	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
90-Waterjet - Flow - 1	M6061T6S.050	0	63	0	
Part Specifications					
Specifications could not be found.					

Plex 3/3/20 8:18 AM Dart.Renwick.Jennifer

2 SHOP COPY

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 203471



D5787-1 PLACARD
(DERIVED FROM AERO DESIGN P/N 77627-01 & P/N 94027-01)

UNDER REVIEW

URF 2020-525 20.02.20 (NO)

NOTES:

- 1) MATERIAL: 6061-T6/T82/T851 ALUMINUM SHEET OR PLATE, 0.050 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.3 AS SHOWN
USE 0.002-0.010 DEPTH AND MIN TOOL RAD OF 0.010
- 7) WEIGHT: 0.03 lbs
- 8) ENGRAVE DART LOGO AND ALL TEXT 0.002-0.010 DEEP WITH MIN TOOL RAD OF 0.010
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D5787-1 REVA.STEP"

RELEASED

2020 FEB 19
ECN 2480-524

APPROVED

A NEW ISSUE		MW	20.01.22
REV.	DESCRIPTION	BY	DATE
DESIGN	MW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5787	SHEET 1 OF 2
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	PLACARD	NTS
DATE	20.01.22	COPYRIGHT © 2020 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR ANY PUBLISHED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT DART AEROSPACE LTD'S WRITTEN PERMISSION	

PO No	Supplier	Line Item No	Rel No	Items	Purchased Item	Description	For Part No	Project	Equipment ID	Order Qty	Due Date	Required Quantity	Accounting Job No	Container No	Status	Receive Date	Price/Unit
PO000123	ACME INC	1		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00
		2		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00
		3		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00
		4		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00
		5		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00
		6		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00
		7		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00
		8		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00
		9		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00
		10		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00
		11		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00
		12		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00
		13		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00
		14		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00
		15		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00
		16		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00
		17		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00
		18		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00
		19		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00
		20		1	1000	1000				10	12/25/18	10		000001	Stock	12/25/18	1.00

File 2025101404 PM Post-Debris-2-1-04

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: 07606165.050

PO / BATCH NO: 037126/1048658

DATE: MAR 07 2010

MATERIAL CERT REC'D: YES

THICKNESS ORDERED: 1.050

QUANTITY RECEIVED: 9012

THICKNESS RECEIVED: 1.050

QUANTITY INSPECTED: 9012

SHEET SIZE ORDERED: 4X12

QUANTITY REJECTED: 0

SHEET SIZE RECEIVED: 4X12

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y N	
CORRECT FINISH	Y N	
CORROSION	Y N	
CORRECT GRAIN DIRECTION	Y N	
CORRECT MATERIAL PER D -DRAWING	Y N	<u>Q3-A-250/11</u>
CORRECT THICKNESS	Y N	
PHOTO REQUIRED	Y N	
CORRECT REF # TO LINK CERT	Y N	<u>Heat # 32112701</u>
CORRECT MATERIAL IDENTIFICATION	Y N	
CORRECT M# ON THE MATERIAL	Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS</u>	SIGNED OFF BY: _____		
DATE: <u>8-00 MAR 07 2010</u>	DATE: _____		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

SPECIFICATION CONTROL DRAWING

PURCHASE MATERIAL: 6061-T6/T62 ALUMINUM SHEET

SPECIFICATION: QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4075 OR AMS 4027
OR ASTM B209

PART NUMBER: M6061T6S XXX
THK

WHERE "XXX" = SHEET THICKNESS (IN INCHES)

EG. 0.063" THICK SHEET = M6061T6S.063

PREFERRED SIZE XXX BY 4FT BY 8FT

RELEASED
2009-09-10

B	REFORMAT DWS 420 B209 SPEC (2N US 1)	CP	09.07.13
A	NEW ISSUE	PS	01.09.08
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR			
APPROVED			
DE APPR			
DATE	09.07.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO: M6061T6S
REV 15
SHEET 1 OF 1
SCALE: NTS

6061-T6 SHEET SPEC

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DELIVERY - CLIENT

Copy CO00075982

ACTER OUELLETTE INC.

935, Boul. du Hêtre
Salaberry de Valleyfield (Québec) J6S 5L1
Tél.: 450-377-4248 MB: 514-336-4248 Ext.: 800-667-4248
Fax: 450-377-5696 MB: 514-336-4246 Ext.: 866-450-4242

Customer N° CLIC001056
Date 2018/02/27
Delivery date 2018/03/06
Your order N° 39126
Processed by Josianne Bourdon
Salesman
Carrier OUELLETTE VALLEYFIELD
Credit Terme Net 30 Days
Page 5

Billed to
DART AEROSPACE LTD
1270, ABERDEEN ST.
BARNESBURY, Ontario, K8A 1K7

Shipped to
, Ontario,
At: CHANTAL LAVOIE Tél.: 613-632-5200

Instruction FM

Delivery Route 5

Product Description	Weight	Qty	U/M	PCS NB			Internal Use Only				
				CND	EXP	S/O	IN	I	S	C	OUT
16 FLAT ALU 3/4 X 4 6061-T6 FAL 344 2596 1 X 12' HEAT: 30740	42.39	12.60	PL \$CLB		1X12'		12'				MAR 07 2018
17 FLAT SS 3/4 X 2 1/2 SS304 RANDOM NG FSS-34212 N 8747 3 X 12' HEAT: 36920 ACT.3597-MM-25-03	229.50	36.00	PL \$CLB		2X12' 1X10'		36'				MAR 07 2018
18 ALU SHEET .051 (100) 6061-T6 (4 X 12) FAL-0514120861 3145 2 X 4 X 12' HEAT: 32115/01 TRANSIT ST JEROME LE 26/02	68.93	96.00	PL2 \$CLB		2X12'		96' 1/2				MAR 07 2018

NIR: R-109515-6

Next Page...



DELIVERY - CLIENT

Copy CO00075982

ACIER OUELLETTE INC.

935, Bvd. du Havre
Salaberry de Valleyfield (Québec) J6S 5L1
Tél.: 450-377-4248 MB: 514-336-4248 Ext.: 800-567-4248
Fax: 450-377-5696 MB: 514-336-4246 Ext.: 866-156-4242

Customer N° CLI0001056
Date 2018/02/27
Delivery date 2018/03/05
Your order N° 39126
Processed by Josianne Bourdon
Salesman
Carrier OUELLETTE VALLEYFIELD
Credit Terms Net 30 Days
Page 5

Billed to
DART AEROSPACE LTD
1270, ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Shipped to

Ontario

Att : CHANTAL LAVOIE Tél.: 613-632-5200

Instruction FM

Delivery Route 5

Product Description	Weight	Qty	U/M	PCS NB			Internal Use Only				
				CM2	EXP	B/O	IN	I	S	C	OUT
16 FLAT ALU 3/4 X 4 6061-T6 PAL 3/4 2596 7 X 12' HEAT: 70740	42.29	12.00	PL_SCLB		1X12'		12'				MAR 07 2018
17 FLAT SS 3/4 X 2 1/2 SS304 RANDOM NS RSS-04212-V 2767 7 X 12' HEAT: 28000 AC13997MM-03-03	229.50	36.00	PL_SCLB		2X12' 1X6' 10"		36'				MAR 07 2018
18 ALU SHEET 051 (16G) 6061-T6 (H X 12) FEAL-0514126061 3145 7 X 4' X 12' HEAT: 32115/01 TRANSIT ST-JEROME LE 28/02	68.93	96.00	PI2_SCLB		2X4' 12'		96' 1/2				MAR 07 2018

NIR : R-109516-6

Next Page...



Abnahmeprüfzeugnis 3.1 (EN 10204)
Inspection certificate - mill certificate

Nr.: 89051448
Rev.: 0

Seite / page: 1 von / of 2

Datum / date: 2017 05 29

Zertifiziert nach / certified to ISO 9001, ISO/TS 16949, ENAS 0100, ISO 14001, NADCAP

Warenempfänger / consignee: CBS Atlanta 1500 Cherokee Pkwy ACWORTH GA 30102-1603 USA	Bestell Nr. / order no.: 5400341710-R01
	Datum / date: 2017 02 23
	Auftragsbest. Nr. / order confirm no.: 127031
	Datum / date: 2017 02 24
	Lieferschein Nr. / delivery note: 89051448
	Datum / date: 2017 08 30

Produkt / product: Form / form: Sheet Werkstoff / material: 6061 Zustand / temper: T6 Dim. / dim.: [inch] 0,050x45,00x144,00 Kundenartikel Nr. / cust. article no.: ALFLR01845	Bedingungen / terms: Technische Lieferbedingungen / techn. spec.: AMS-CQ-A-250/11, 08.1997 ASTM B 208 - 14 AMS 4027N, 07.2008 ASME SB-209, 2011a Sondervorschrift / special terms:
------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------

AB-Pos. ord.-item.	BHr/Los Lot/No.	Teillos Part	Guss Nr. cast no.	Werkstoff/ material	Kollo pack.no.	Gewicht netto weight net	Stk. pcs.
03	32115/01	00	01/0082348/7	6061	1270310006	4001,323 lbs	119
03	32115/01	00	01/0083055/7	6061	1270310007	3977,072 lbs	119

Chemische Zusammensetzung [%] Gewichtanteile / Chemical composition [%] weight proportion (OES)											
Guss Nr. / cast no.	material	Si	Po	Cu	Mn	Mg	Cr	Zn	Ti	Others Each	Others Total
01/0082348/7	6061										
	spec. min.	0,40	-	0,15	-	0,80	0,04	-	-	-	-
	spec. max.	0,80	0,70	0,40	0,15	1,20	0,35	0,25	0,15	0,05	0,15
	actual	0,68	0,40	0,26	0,13	0,98	0,17	0,05	0,03	0,02	0,03
01/0083055/7	6061										
	spec. min.	0,40	-	0,15	-	0,80	0,04	-	-	-	-
	spec. max.	0,80	0,70	0,40	0,15	1,20	0,35	0,25	0,15	0,05	0,15
	actual	0,35	0,38	0,23	0,11	0,87	0,17	0,06	0,03	0,01	0,03

Zugprüfung LT / tensile test LT									
BHr/Los Lot/No.	Zustand temper	Richtung direction	Tests		UTS [ksi]	YS [ksi]	A2 ⁺ [%]		
				spec.min	42,0	35,0	10		
				spec.max	-	-	-		
32115/01	T6	LT	2	from	45,8	35,5	17		
32115/01	T6	LT		to	46,0	35,8	17		

AK 166V

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause <div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		FAULT CATEGORY <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
Other/Details:					